

### ABSTRACT OF THE DISCLOSURE

According to the invention, a micro-structured element is manufactured by replicating/shaping (molding or embossing or the like) a 3D-structure in a preliminary product using an replication tool (1). The replication tool comprises a  
5 spacer portion (1c) protruding from a replication surface (1a). The replica (the micro-structured element, for example the micro-optical element or micro-optical element component) may be made of epoxy, which is cured – for example UV cured – while the replication tool is still in place. The replication process may be an embossing process, where the deformable or viscous or liquid component of the preliminary  
10 product to be shaped is placed on a surface and then the replication tool is pressed against this surface. As an alternative, the replication process may be a molding process.

(Fig. 1)